

ABSTRACT OF THE DISCLOSURE

In a method for manufacturing internally and/or externally profiled rings from pipe material or solid material, machine-cutting processes and forming processes are combined with one another sequentially, parallel, or sequentially and parallel, wherein one of the forming processes is roll forming. During roll forming a counterforce is generated relative to a flow direction of the starting material so that a material flow in at least one of an axial direction and a radial direction of the starting material is controlled such that flowing material is integrated into a profile to be shaped on the ring.